



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3912-1

Job Sheet 200869



Part No: D3912-1

Job Qty: 30 pcs

Part Name: Eyebolt

27 pcs. D.A.



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/18/19

Job Tracking No:

Due Date: 10/16/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B IPP RevA: New issue DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	Doosan - 1	30 pcs	10/16/19	10/16/19	1.00	21.43	Doosan - 1	19/10/11
110	QC 2	30 pcs	10/16/19	10/16/19	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	
							QC 2 - 8	
							QC 2 - 66	
							QC 2 - 64	
							QC 2 - 65	19/10/11

DAS
65
9-89

DAS
65
9-89

Plex 9/18/19 12:14 PM Dart.lajeunesse.marie

120 QC 8	30 pcs	10/16/19	0.00	0.00	QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
130 Packaging 3-1 - Stock - B4B	30 pcs	10/16/19	0.00	0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	

19-10-16

PC ST 656

				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140	QC 21 - SA	30 pcs	10/16/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53
Part Op 100 - (Doosan Lathe) TURN AS PER FOLIO FA871AND DWG Prog Rev: _____ Debur as required Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB) 120 - (QC8- Inspect parts - second check) 130 - (Identify as per dwg & Stock Location: _____) 140 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M303R2.000	303 Round Bar 2"	8.4000 ft (.28 ea)	100-Doosan - 1	S16b56b	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Doosan - 1	M303R2.000	8	7	0	

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Eyebolt	0.130Inches ± 0.030	0.160 0.100		
2	Eyebolt	0.700Inches ± 0.010	0.710 0.690		
3	Eyebolt	0.500Inches ± 0.010	0.510 0.490		
4	Eyebolt	0.900Inches ± 0.030	0.930 0.870		
5	Eyebolt	0.130Inches ± 0.030	0.160 0.100		
6	Eyebolt	45.0Degrees ± 0.5	45.5 44.5		
7	Eyebolt	0.220Inches ± 0.030	0.250 0.190		
8	Eyebolt	0.750Inches ± 0.030	0.780 0.720		
9	Eyebolt	0.970Inches ± 0.010	0.980 0.960		
10	Eyebolt	1.720Inches ± 0.030	1.750 1.690		
11	Eyebolt	1.200Inches ± 0.030	1.230 1.170		
12	Eyebolt	0.6250Inches ± 0.0100	0.6350 0.6150		
13	Eyebolt	2.230Inches ± 0.030	2.260 2.200		
14	Eyebolt	0.130Inches ± 0.030	0.160 0.100	Radius	
15	Eyebolt	0.015Inches ± 0.010	0.025 0.005	Radius	
16	Eyebolt	0.625Inches ± 0.010	0.635 0.615		
17	Eyebolt	0.650Inches ± 0.010	0.660 0.640		
18	Eyebolt	1.100Inches ± 0.010	1.110 1.090		
19	Eyebolt	0.440Inches ± 0.030	0.470 0.410		
20	Eyebolt	0.130Inches ± 0.030	0.160 0.100	Radius	
21	Eyebolt	1.000Inches ± 0.030	1.030 0.970		
22	Eyebolt	0.250Inches ± 0.030	0.280 0.220		
23	Eyebolt	0.880Inches ± 0.030	0.910 0.850		
24	Eyebolt	0.110Inches ± 0.030	0.140 0.080		
25	Eyebolt	0.719Inches + 0.010 - 0.000	0.729 0.719		

Plex 9/18/19 12:14 PM Dart.lajeunesse.marie

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube Machining ☐ Cross tube Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐																													
Date : _____		Sequence #: _____		QTY Affected : _____																													
Description Work Order Deviation		Disposition																															
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY <table border="1"> <tr> <td>Pressure/Forced</td> <td>Contamination</td> <td>Power Loss/Surge</td> <td>Positioned Wrong</td> </tr> <tr> <td>Bending</td> <td>Misaligned/off center</td> <td>Folio/Program</td> <td>Outside Tolerance</td> </tr> <tr> <td>Crushing</td> <td>BOM/Route</td> <td>Grain Direction</td> <td>Drawing</td> </tr> <tr> <td>Cracks</td> <td>Broken/Damage/Defect</td> <td>Weld</td> <td>Finish</td> </tr> <tr> <td>Crimp/kink/Ripple/Wave/Twist</td> <td>Incomplete/Unclear Instructions</td> <td>Wrong Stock Pulled</td> <td>Part Lost/Missing</td> </tr> <tr> <td>Marks/Chatter</td> <td>Drill Holes</td> <td>Out of Sequence</td> <td>Misread</td> </tr> <tr> <td>Mislabeled</td> <td>Fit/Function</td> <td>Off-set/Set-up</td> <td></td> </tr> </table>				Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong	Bending	Misaligned/off center	Folio/Program	Outside Tolerance	Crushing	BOM/Route	Grain Direction	Drawing	Cracks	Broken/Damage/Defect	Weld	Finish	Crimp/kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing	Marks/Chatter	Drill Holes	Out of Sequence	Misread	Mislabeled	Fit/Function	Off-set/Set-up	
Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong																														
Bending	Misaligned/off center	Folio/Program	Outside Tolerance																														
Crushing	BOM/Route	Grain Direction	Drawing																														
Cracks	Broken/Damage/Defect	Weld	Finish																														
Crimp/kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing																														
Marks/Chatter	Drill Holes	Out of Sequence	Misread																														
Mislabeled	Fit/Function	Off-set/Set-up																															
Other/Details: _____		Completed By _____ Lead hand / Supervisor _____ QC / QA Coordinator _____																															